

5/44

DART AEROSPACE LTD	Work Order:	24641
Description: Crossbolt Spacer	Part Number:	D2743
Dwg: D2743 Rev. B	Qty:	197 <i>200</i>

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>MM</i>	05/10/21	200
2	MC	Machine as per Folio FA202 and Dwg D2743 Material: 6061-T6 (WW-T-700/6) Ø0.625" x 0.065" wall (M6061T6T0.625W.065) <b>Identify for D2743</b>			
		Batch: <u>M16991</u>	<u>S.G</u>	<u>05/11/01</u>	<u>200</u>
3	QC2	Inspect parts as they come off the machine <b>Identify as D2743</b>	<u>S.G</u>	<u>05/11/03</u>	<u>200</u>
4	QC8	Second check	<u>ML</u>	<u>05/11/03</u>	<u>200</u>
5	ST	Identify and Stock	<u>PL</u>	<u>05/11/07</u>	<u>197</u>
6	AC	Cost / part: <u>78</u>	<u>SAC</u>	<u>05-11-00</u>	<u>197</u>
7	DC	Close W/O, <u>85</u> Inspect Level 21	<u>(K)</u>	<u>05/11/09</u>	<u>197</u>

Rev	Date	Change	Revised By	Approved
A	98.09.10	New issue	DS/CP	
B	99.01.04	Drawing to Rev. B	DM	
C	99.11.02	Re-format, Outside contract	EC	
D	02.03.07	Now made in house	NG	
E	05.04.13	Reformat; removed tumble and deburr step	KJ/JLM	<i>JLM</i>

RELEASED  
*05-01-14*

15  
15  
15  
15

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector		
			Initial Design Mgr	Action Description Design Mgr	Sign & Date					

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

DQA: 17Date: 05/11/09

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

DART AEROSPACE LTD	Work Order:	24641
Description: Cross Bolt Spacer	Part Number:	D2743
Inspection Dwg: D2743 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>J. G</u>	Audited by: <u>SJ</u>	Prototype Approval:	N/A
Date: <u>05/11/02</u>	Date: <u>05/11/02</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	DE

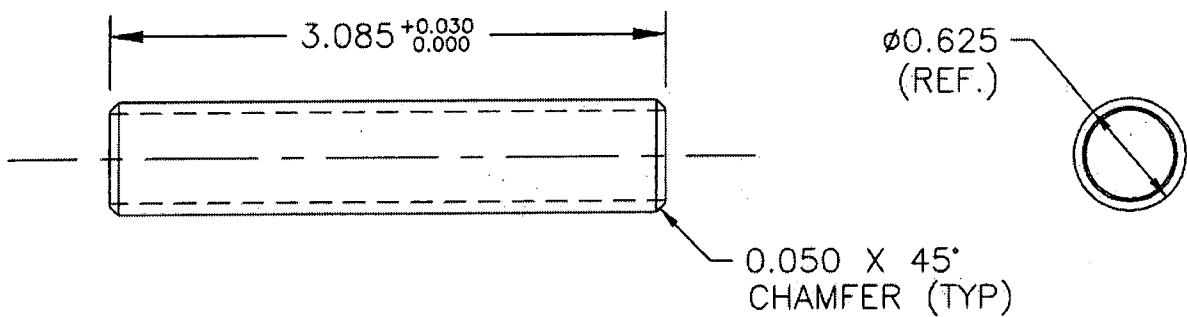
RELEASED

12 04-04-26



DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2743 REV. B SHEET 1 OF 1
DATE		TITLE
98.12.08		CROSS BOLT SPACER
A	98.04.16	SCALE 1:1
B	98.12.08	3.085 WAS 3.060

RELEASED  
98.12.16 DS



MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
COPY  
PRINTED  
WITHOUT NOTICE

WORK ORDER  
NO. 24641

## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyOct 20, 2005  
04:09 pm

Work Order No : 0024641  
 Project Name : D2743  
 Project For : WK544  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D2743  
 Description : Crossbolt Spacer  
 Manufactured : Yes  
 Amount Req'd : 200  
 Amount Done : 0  
 Start Date : 10-20-05  
 Est Finish Date : 11-04-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :  
 Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%  
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
===== ===== =====					
Burden :	0.00	0.00	0.00		
===== ===== =====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

Date: Wednesday, 11/9/2005 7:16:23 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CROSSBOLT SPACER		
Job Number	: 24641		Part Number	: D2743		
Estimate Number	: 10329		Drawing Number	: D2743 REV B		
P.O. Number	:		Project Number	:		
This Issue	11/9/2005	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	/ /	Type : MACHINED PARTS	Due Date	11/16/2005	Qty:	197
Previous Run	: 24743		Um:	Each		
Written By	:					
Checked & Approved By	:					
Comment	: Est E 05.04.13 Reformat; removed tumble and deburr step KJ/J LM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0625W065	6061-T6 Tube .625 x.065W
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
<b>Comment:</b> HARDINGE CNC LATHE SMALL Machine as per Folio FA202 and Dwg D2743		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<b>Comment:</b> SECOND CHECK		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: _____		
6.0	DC	DOCUMENT CONTROL
<b>Comment:</b> DOCUMENT CONTROL Inspection Level 21		

Job Completion



Created in  
M's and in  
closed pi's

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
12:42 pm

Work Order No : 0024641  
 Project Name : D2743 Department Code:  
 Project For : WK544 Burden Flags : NNNNNNN  
 Work Order Type : Main WO Status : Open  
 Main WO Number : Invoice State : Not Invoiced  
 House Part Number : D2743 Invoice Date :  
 Description : Crossbolt Spacer Invoice Number :  
 Manufactured : Yes Invoice Amount : 0.00  
 Amount Req'd : 200  
 Amount Done : 0 Order Entry No :  
 Start Date : 10-20-05 OE Value : 0.00  
 Est Finish Date : 11-04-05  
 Act Finish Date :  
 Drawings Reqd : No Est Margin : 0.000%  
 Ok for Approval : Actual Margin : 0.000%  
 Approval Rec'd : \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	3.00	100.00		
Production Cost :	0.00	50.93	100.00	0.00	50.93
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	3.00	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
===== ===== =====					
Burden :	0.00	0.00	0.00		
===== ===== =====					
Total Cost :	0.00	50.93	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	50.93			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	( -50.93 )

Opening balance  
W/ 0.00  
08/11/09

Date: Wednesday, 11/9/2005 8:24:33 AM

User: Linda Lacelle

**INVENTORY ITEMS PICKED****FOR SLIP NUMBER 4**

**Project No.** :  
**Customer** : Dart Helicopters Services  
**Part Number** : D2743  
**Job Number** : 24641

**Drawing Number** : D2743 REV B  
**Drawing Name** : CROSSBOLT SPACER  
**Due Date** : / /  
**Qty** : 20  
**Slip #** : 4

	<b>Location</b>	<b>Store</b>	<b>Picking</b>	<b>Lot No.</b>	<b>Serial No.</b>	<b>Req'd</b>	<b>Taken</b>
1.0 M6061T6T0625W065 6061-T6 Tube .625 x.065W							
<b>Available</b> 69.00	MAIN			16191	5.60	7.1600 f	
	MAIN			18530	5.60	48.0000	